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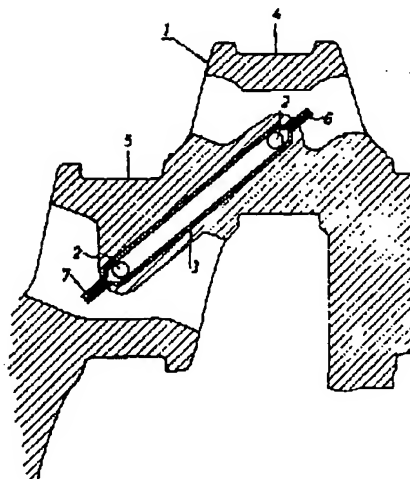
(54) **METHOD FOR MANUFACTURING OIL HOLE OF
HOLLOW CRANK SHAFT**

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(57) Abstract

PURPOSE: To form oil holes accurately in required positions by fixing a pipe which is blinded at both ends in such a manner that its end faces are not exposed to machining surfaces by using cores and casting a crank shaft then piercing crossing holes in said pipe.

CONSTITUTION: End parts 6 and 7 of a pipe 3 are blinded, and one end part 6 thereof is fixed to the core for forming hollow part of a pin part 4 and the other end part 7 is fixed to the core for forming hollow part of a journal part 5. In this case, the length of the pipe 3 is beforehand so selected that said end parts 6 and 7 are not exposed to the machining surfaces of the pin part 4 and journal part 5. Thence, molten metal is poured by an ordinary method and after the solidification of the molten metal, the core sand is discharged. Thence, crossing holes (oil holes) 2 are pierced to the pipe 3 by drilling or the like, whereby the hollow crank shaft 1 provided with the oil holes 2 is obtained.



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Fig. 2

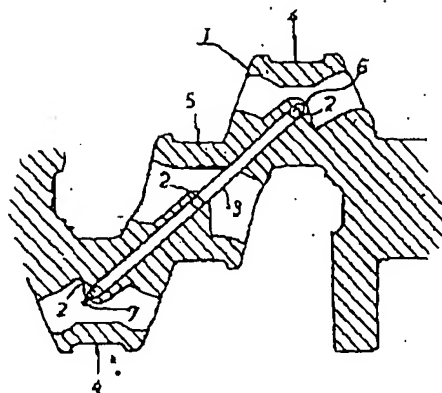


Fig. 3

